

Work Order ID 51806

Page 1

Thursday, September 03, 2009 11:44:32 AM

Item ID: D350-636-012

Accept



Setup Start



Revision ID: F

Stop



Item Name: Skidtube RH

Start Date: 9/3/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *PL*Date: *09-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2750

Rev F

100

0.00



DC

DOCUMENT CONTROL

0.00

Document Control

Memo

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

S orl orl

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Setup Start



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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

110

0.00



Skidtubes

Skidtubes

Skidtubes

Memo

0.00

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004
A/R ☐ ☐ Aluminum Rod ☒ mill 682

10-Grind welds flush as per Dwg D2750

BE 09/09/09

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11- scribe batch #.

120

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

Quality Control

⇒ S 09/09/09



φ

130

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

⇒ S 09/09/09



φ

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing



φ

09/09/09

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

160



Skidtubes

Skidtubes

0.00

Memo

0.00

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R ☐☐☐ Sikaflex-291 batch: 112391 ☐☐☐
exp. date: 02/2010

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9)

A/R ☐☐☐ Aluminum Rod batch: 1111682

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

BE 09/09/09

BE 09/09/10

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Reference:

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

11-Deburr holes

170



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

2) 509/09/10

0.00

Memo

40

φ

180



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

2) 509/09/10

0.00

Memo

40

φ

190



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

2) 509/09/10

0.00

Memo

x1

0

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Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 11112260 START TIME: 11:00am OVEN TEMPERATURE: 320°F FINISH TIME: 11:30am	0.00 0.00	94	09/09/10		XL	Ø		
210  QC Quality Control	QC3- Inspect Part Finish Memo Inspect for foreign object per QSI 024	0.00 0.00	BR	09-09-10		①			
220  HandFinish Hand Finishing	HandFinishing Memo Install inserts as per dwg D2750	0.00 0.00	94	09/09/10		①	Ø		

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230



HandFinish

Hand Finishing

HandFinishing

Memo

✓ 1-Inspect for Foreign Objects

✓ 2-Spray inside of tube with "LPS-3"
batch: MIA3-Install blade fitting D3488-042, wearshoes and ground handling hardware as
per dwg D2750
SIKA FLEX 241L BATCH: 1A 117391
EXP DATE: 10/284-assemble o'ring to plug as per dwg D3492 and apply o'ring lube
A/R 55-o'ring lube batch: M1012235-Coat all exposed fasteners with "LPS Procyon"
batch: M104258

0.00

0.00

9/09/08/10

21 6

240



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

9/8/08/10

40 4

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Cust Item ID:

Required Date: 9/15/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250 Pick Kit		0.00							
Packaging	Memo	0.00				9/9/10		(17)	SP
Packaging									
260 QC	QC4- 100% Inspect kits for completeness	0.00							
Quality Control	Memo	0.00				(16)			
270 Packaging	Packaging	0.00							
Packaging	Memo	0.00				9/9/10		(18)	SO
Packaging	Package as per PPP D350-636-012								

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Start Date: 9/3/2009 Start Qty: 1.00

Required Date: 9/15/2009 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/09/10 *[Signature]*
MF 09-09-10

Picklist Print

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Work Order ID: 51806

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
ALS4-1032-225		Purchased	No			220	Each	8,785.000	38.0000			

Insert

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

8785

107441

16

110768

8769

AN3C5A

Purchased

No

230

Each

646.0000

34.0000



Bolt

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

646

111424

8

111707

338

112314

200

112489

100

AN3C6A

Purchased

No

230

Each

1,048.000

4.0000



BOLT

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

1048

110372

72

111982

976

X38 MD 09/09/10

X34 MD 09/09/10

X4 MD 09/09/10

Picklist Print

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Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN6C44A		Purchased	No			230	Each	172.0000	4.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	2	
103964	2	
Main Warehouse		
ST	170	
110105	4	
110155	14	
110665	1	
110865	51	
111605	50	
111649	50	

X4 MD 09/09/10

AN8C35A

Purchased

No

230

Each

167.0000

1.0000



BOLT

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	167	
102180	1	
106896	1	
110105	65	
110847	100	

X1 MD 09/09/10

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Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH


Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960C10L  washer		Purchased	No			230	Each	2,450.000	38.0000			

Warehouse Loc Qty Loc Code

Location

OFFSHORE

FG 100

103585 100

Main Warehouse

FP -44

112116 -44

Main Warehouse

ST 2394

112116 2394

AN960C816L

Purchased

No

112116

230

Each

330.0000 1.0000



WASHER

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 330

104093 2

107520 4

110139 29

110372 36

110584 100

111424 159

X38 MD 09/09/10

X1 MD 09/09/10

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Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH



Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2745RevB		Manufactured	No			230	Each	272.0000	8.0000			
												
Bushing												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	272	
34817	2	
36230	8	
37303	1	
39587	2	
40726	2	
41114	2	
42778	19	
43754	2	
44893	37	
45556	69	
46695	18	
48278	110	

X8 MO 09/09/10

D3488-042RevB

Manufactured No

230

Each

9.0000

1.0000



Blade Fitting Assembly, RH

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	9	
29043	1	
44531	8	

X1 MO 09/09/10

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Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3492-041RevC		Manufactured	No			230	Each	3.0000	8.0000			

Plug Assembly

Handwritten mark

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43816

47658

3

x8 MD 09/09/10

D3492-043RevC

Handwritten mark

Manufactured

No



Plug Assembly

D3535-25RevB

Manufactured

No



Wearshoe

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

47523

11

11

x1 MD 09/09/10

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Start Date: 9/3/2009

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Comments:

Start Qty: 1.00

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3536-25RevA

Manufactured

No

230

Each

21.0000

1.0000



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

21

45569

1

47011

2

47526

8

50266

10

X1 MD 09/09/10

D3537-1RevC

Manufactured

No

230

Each

46.0000

3.0000



Wearpad

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

FP

46

48288

3

50321

43

X3 MD 09/09/10

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Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3631-1RevA  Washer		Manufactured	No			230	Each	105.0000	8.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

105

38139

6

45353

16

47437

83

D3791-1RevA

Manufactured No



Wearplate

230

Each

18.0000

1.0000



X8 MD 09/09/10

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

47536

8

50269

10

XI MD 09/09/10

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3793-1RevA  Wearshoe		Manufactured	No			230	Each	18.0000	1.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

18

40551

1

47537

4

50231

13

D3793-3RevA

Manufactured No



Wearshoe

230

Each

22.0000

1.0000



Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

22

47720

11

50216

11

XI MD 09/09/10

XI MD 09/09/10

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Comments:

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3794-1RevA 		Manufactured	No			230	Each	7.0000	1.0000			
Gasket												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46530

47212

47721

7

1

2

4

230

Each

27.0000

1.0000



D3794-3RevA

Manufactured

No



Gasket

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

46531

47440

47722

50240

27

2

2

11

12

xl mo 09/09/10

xl mo 09/09/10

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Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-6 		Purchased	No			230	Each	1,132.000	4.0000			
NUT												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

1132

110584

34

111424

98

112314

1000

Y4 mp 09/09/10

MS21083C8



Purchased

No

230

Each

92.0000

1.0000

NUT

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

92

110584

5

111424

2

111637

21

112243

44

112492

20

X1 mp 09/09/10

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAS1611-010  O-RING		Purchased	No			230	Each	345.0000	8.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	345	
110715	50	
110915	295	

(P+D) - D

NAS1611-013  O-RING		Purchased	No			230	Each	320.0000	8.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	320	
106513	11	
111424	109	
111758	200	

18 MA 09/09/10

Thursday, September 03, 2009 11:44:39 AM

Shop Packet Print

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Dart Aerospace Ltd

W/O: 51806		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-09-10	#236	Replaced O-ring NAS1611-010 By O-ring D2594-3 Batch # 29908	MD	09/09/10	x8		01/10/10

Part No: D350-636-012 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 12

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Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN8C21A		Purchased	No			260	Each	112.0000	2.0000			
BOLT												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	112	
105160	1	
107596	1	
107924	2	
109092	2	
110341	2	
110342	4	
111605	50	
111684	50	

111684

AN960C816L

Purchased

No

260

Each

330.0000

2.0000



WASHER



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	330	
104093	2	
107520	4	
110139	29	
110372	36	
110584	100	
111424	159	

111424

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(x)

Picklist Print

Page 13

Thursday, September 03, 2009 11:44:39 AM

Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2741RevC..		Manufactured	No			260	Each	40.0000	1.0000			
Blade, 350 Skidtube												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

40

20770

0

45320

1

47113

39

115.0000

2.0000

47113

SP

D3493-1RevA

Manufactured No

260

Each

115.0000

2.0000

Washer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

44902

15

47710

100

44902

SP

D3532-1RevA

Manufactured No

260

Each

43.0000

2.0000

Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

43

38161

2

44904

41

44904

SP

9/9/10

Q

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Page 13

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Page 14

Thursday, September 03, 2009 11:44:39 AM

Work Order ID: 51806

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH


Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21083C8 S  NUT		Purchased	No			260	Each	92.0000	2.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST	92	
110584	5	
111424	2	
111637	21	
112243	44	
112492	20	

NAS1515H3L

Purchased

No



WASHER

260
230

Each

350.0000

4.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
OFFSHORE		
FG	40	
102472	40	
Main Warehouse		
ST	310	
110450	2	
110806	8	
111819	300	

112243 SP

xy mo 09/09/10 (P40) →

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09/09/10	#260	Route seq ID for washer NPS1515H3L should be 230 instead of 260.	MD	09/09/10			01/10/10 S

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 15

Thursday, September 03, 2009 11:44:39 AM

Work Order ID: 51806

Parent Item: D350-636-012RevF

Parent Item Name: Skidtube RH

Comments:

Start Date: 9/3/2009

Required Date: 9/15/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
S NAS1515H8L WASHER		Purchased	No			260	Each	129.0000	2.0000			

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

129

107581

34

108964

1

111650

94

D2600-3-BENTRevD1

Manufactured

No

110

Each

0.0000

1.0000

Extrusion Bent

D2744RevC

Manufactured

No

110

Each

50.0000

1.0000

Cap

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

50

44892

15

47488

35

111650 9/9/10 SP

B 50675
B 46063 2E09/09/09

1 BE 09/09/09

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Picklist Print

Thursday, September 03, 2009 11:44:39 AM

Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2739RevD		Manufactured	No			160	Each	6.0000	1.0000			
350 I Beam												

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	4	
50353	4	
Main Warehouse		
ST	2	
47124	1	
47681	1	

1 BE 09/09/09

D2743RevB

Crossbolt Spacer

Manufactured No

160 Each 294.0000 8.0000



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
LG	50	
50281	50	
Main Warehouse		
ST	244	
44891	2	
45555	177	
48275	65	

0 BE 09/09/09

Picklist Print

Thursday, September 03, 2009 11:44:39 AM

Work Order ID: 51806



Parent Item: D350-636-012RevF



Parent Item Name: Skidtube RH

Start Date: 9/3/2009

Required Date: 9/15/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3490-3RevA		Manufactured	No			160	Each	112.0000	4.0000			
Cross Bolt Spacer												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

112

45560

22

47471

35

48276

55

4 BE 09/07/09

D3490-1RevA

Manufactured No

160

Each

165.0000

4.0000



Cross Bolt Spacer

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

165

45338

2

47118

4

47657

50

48277

109

4 BE 09/07/09

8 7 6 5 4 3 2 1

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

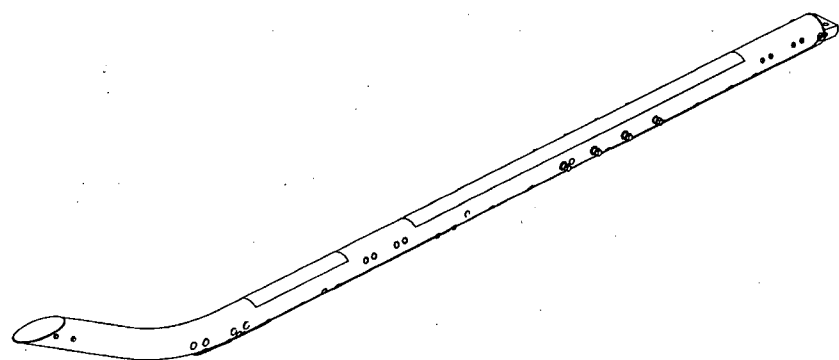
GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

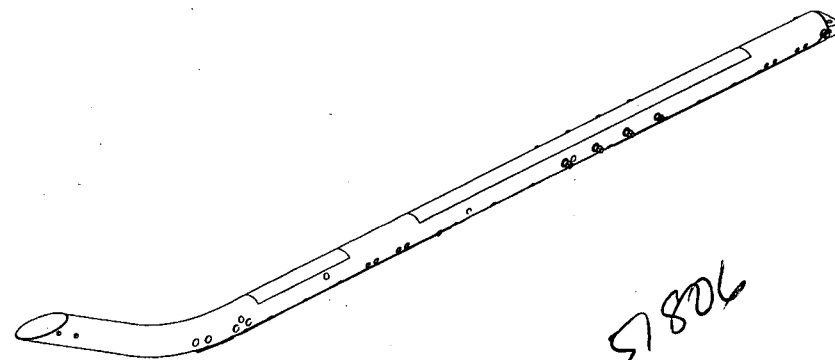
51806

RELEASED

F	INCORPORATE DSI 9413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL), WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741, QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE DEO 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	PORT HADLOCK, WA		
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.07.16		
DART AEROSPACE USA, INC.			
PORT HADLOCK, WA			
DRAWING NO.		REV. F	
D2750		SHEET 1 OF 11	
TITLE		SCALE	
350 SKIDTUBE ASSEMBLY		NTS	
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D2750-041 350 SKIDTUBE ASSEMBLY, LH

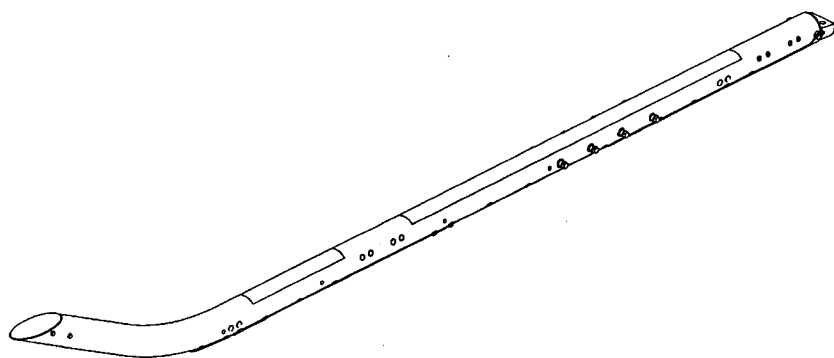


D2750-042 350 SKIDTUBE ASSEMBLY, RH

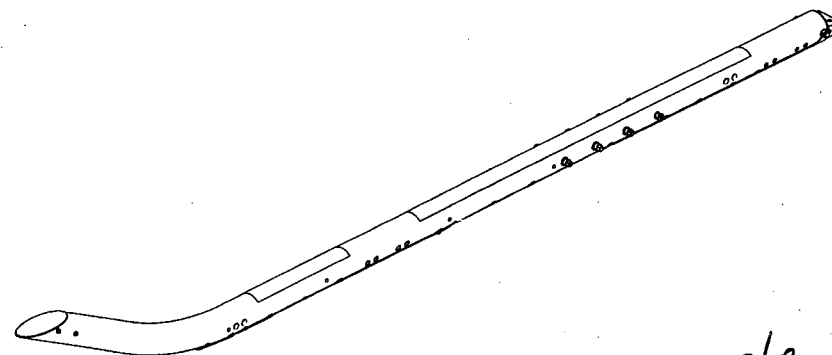
57806

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08.07.16

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DRAWN	<i>AM</i>		
CHECKED	<i>JA</i>	DRAWING NO. D2750	REV. F
MFG. APPR.	<i>MA</i>	SHEET 2 OF 11	
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	08.07.16	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D2750-043 350 SKIDTUBE ASSEMBLY, LH

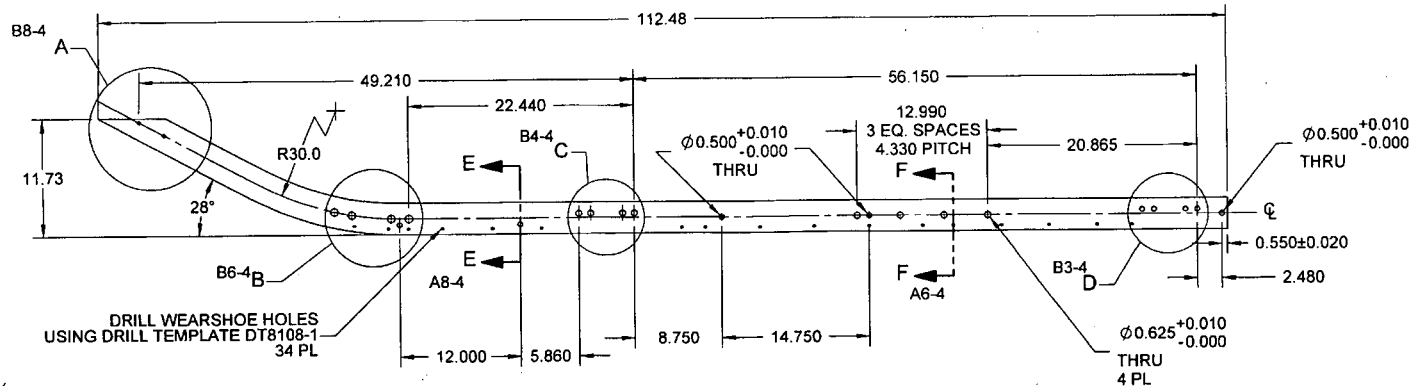


D2750-044 350 SKIDTUBE ASSEMBLY, RH

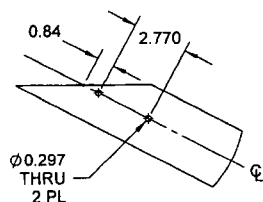
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68-19-11/11

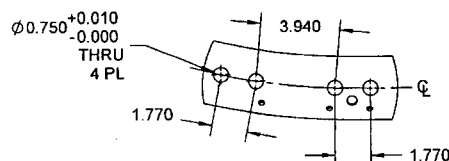
DESIGN		DART AEROSPACE USA, INC.	
DRAWN	<i>PD</i>	PORT HADLOCK, WA	
CHECKED	<i>PD</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>MP</i>	D2750	SHEET 3 OF 11
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.	<i>MP</i>	350 SKIDTUBE ASSEMBLY	NTS
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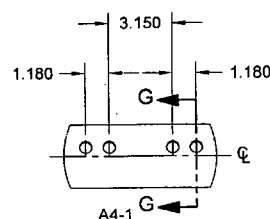
D2750-1 LH SKIDTUBE



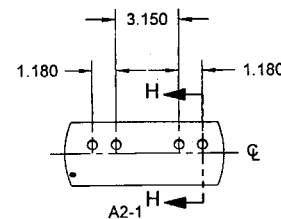
DETAIL A
SCALE 2X



DETAIL B
SCALE 2X



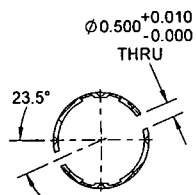
DETAIL C
SCALE 2X



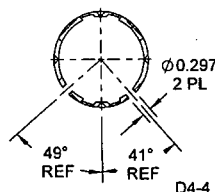
DETAIL D
SCALE 2X

51806

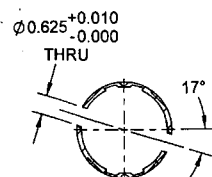
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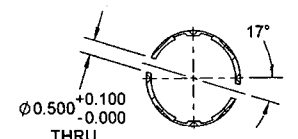
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL

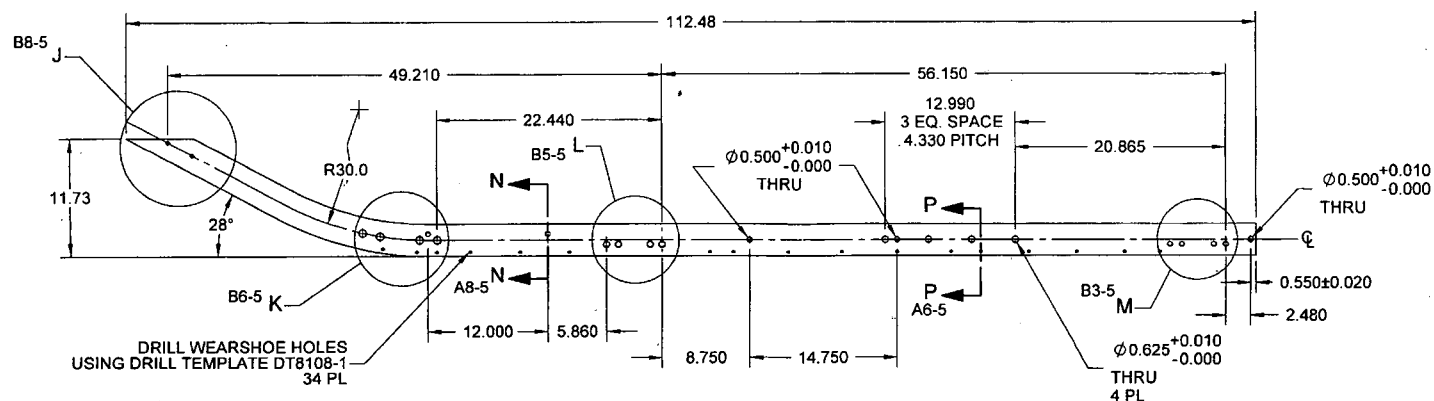


SECTION G-G
SCALE 3X, 4 PL

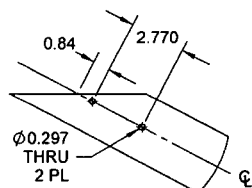


SECTION H-H
SCALE 3X, 4 PL

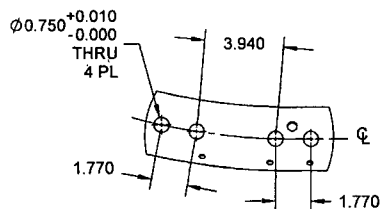
DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 4 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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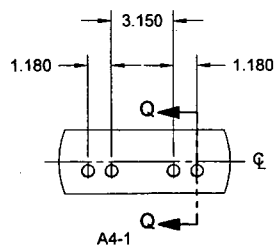
D2750-2 RH SKIDTUBE



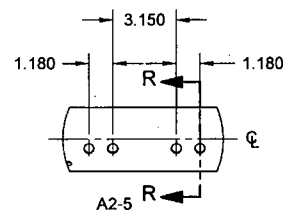
DETAIL J
SCALE 2X



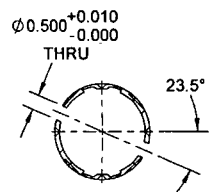
DETAIL K
SCALE 2X



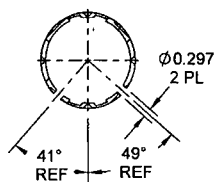
DETAIL L
SCALE 2X



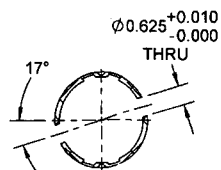
DETAIL M
SCALE 2X



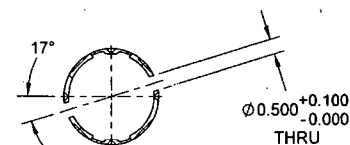
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

DESIGN	REV	DART AEROSPACE USA, INC.	
DRAWN	REV	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. F
MFG. APPR.		D2750	SHEET 5 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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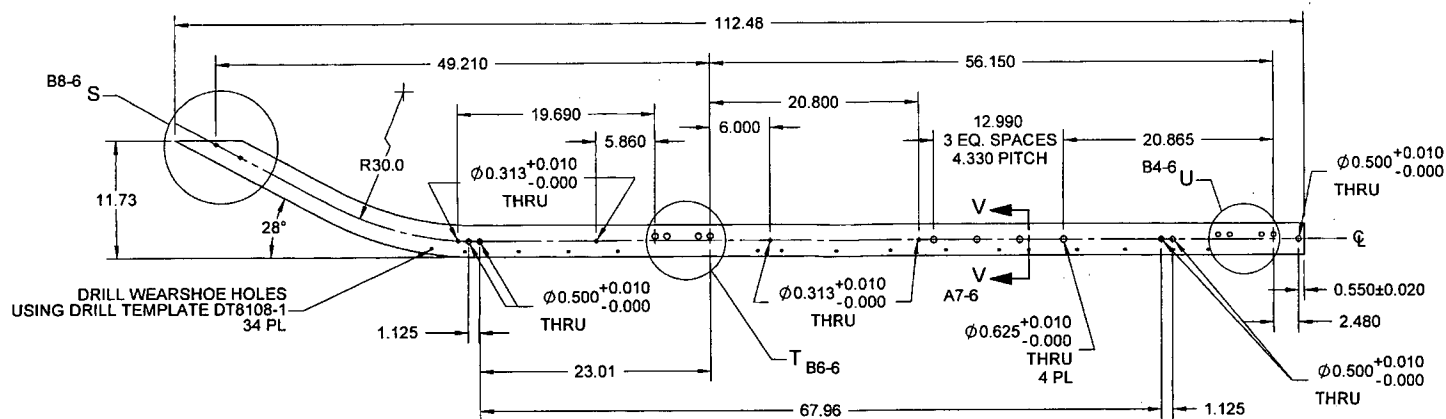
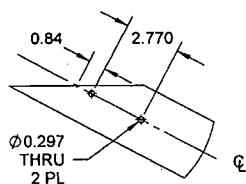
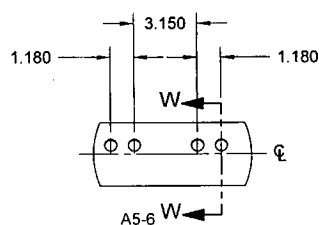
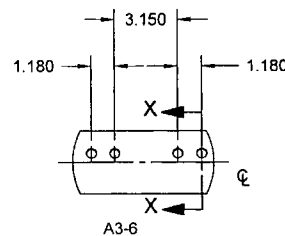
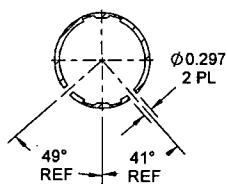
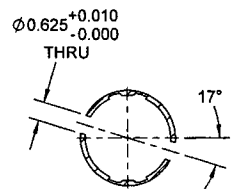
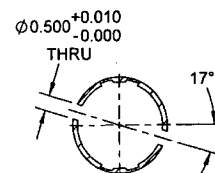
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**D2750-3 LH SKIDTUBE****DETAIL S**
D8-6
SCALE 2X**DETAIL T**
C5-6
SCALE 2X**DETAIL U**
D3-6
SCALE 2X**SECTION V-V**
C4-6
SCALE 3X, 17 PL**SECTION W-W**
B6-6
SCALE 3X, 4 PL**SECTION X-X**
B4-6
SCALE 3X, 4 PL51806
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08-07-16

DESIGN		DART AEROSPACE USA, INC.	
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MFG. APPR.		D2750	SHEET 6 OF 11
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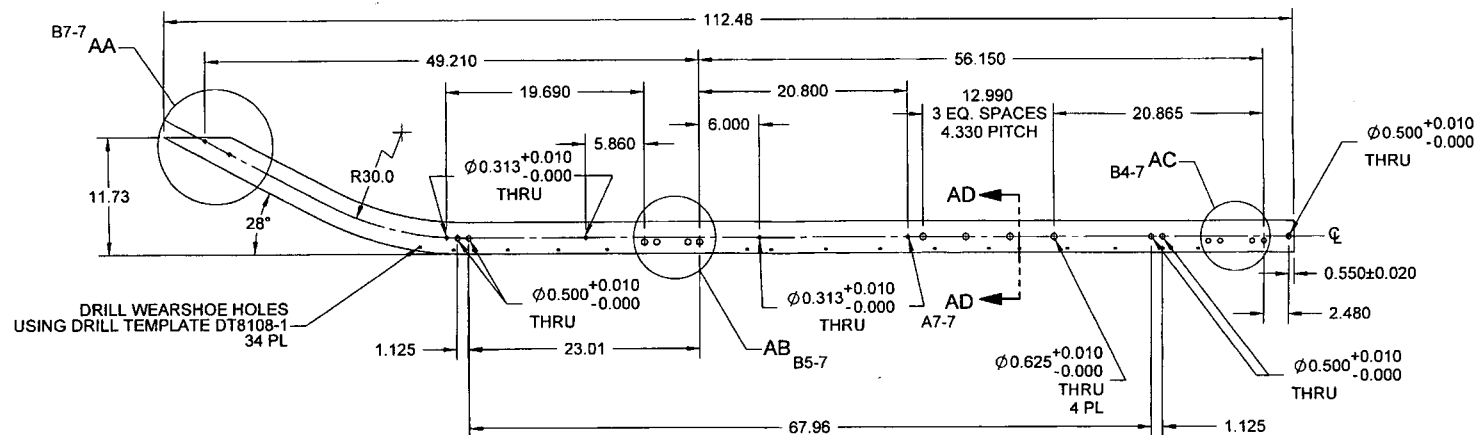
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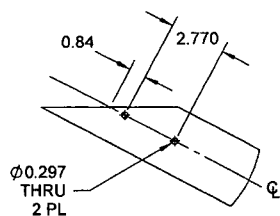
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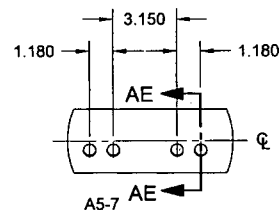
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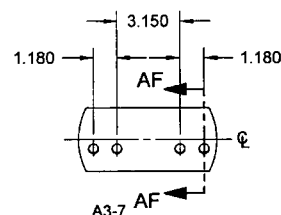
D2750-4 RH SKIDTUBE



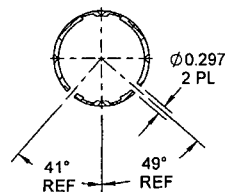
DETAIL AA
SCALE 2X



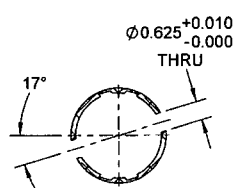
DETAIL AB
SCALE 2X



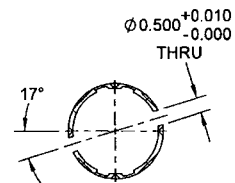
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



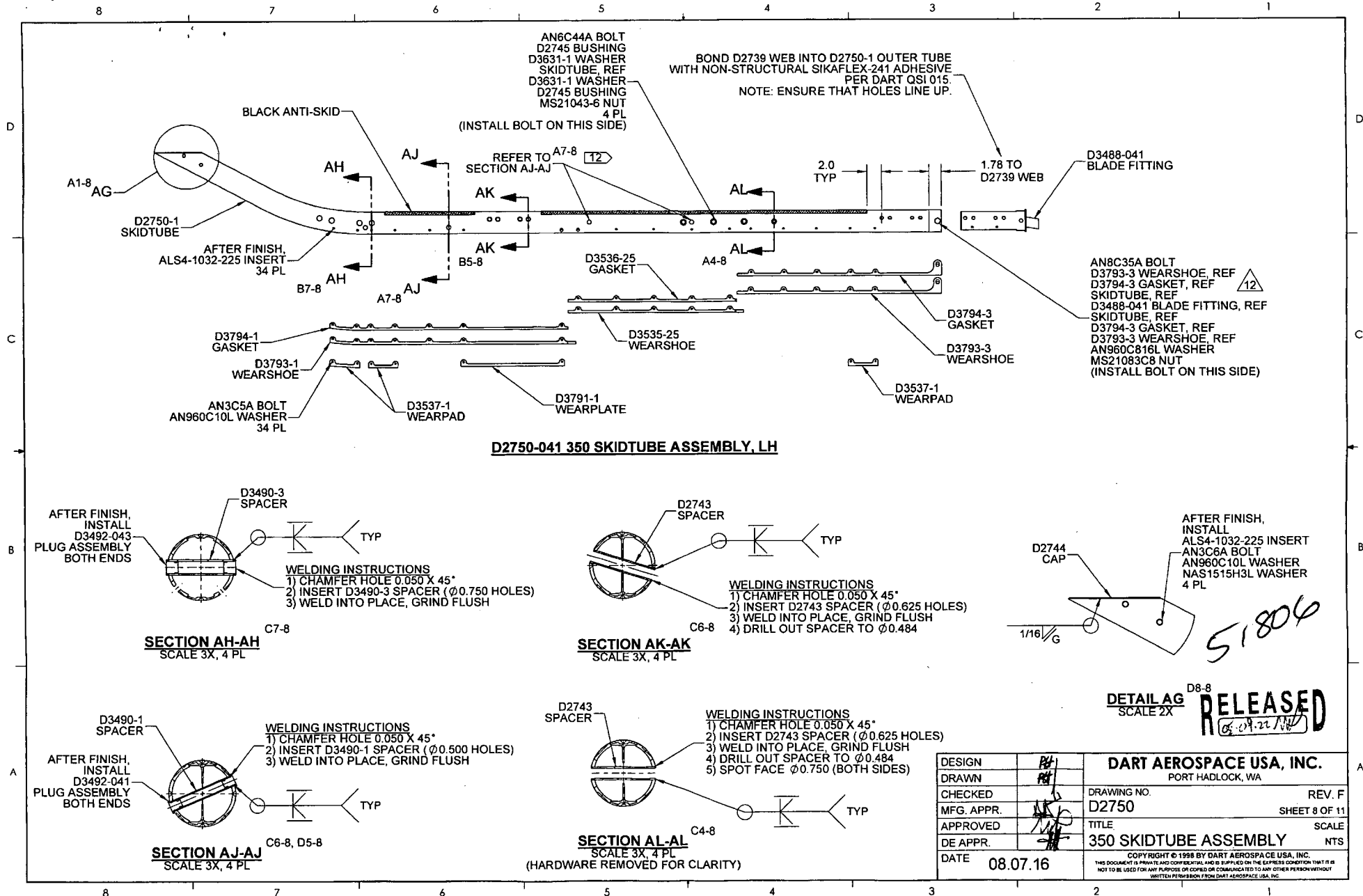
SECTION AE-AE
SCALE 3X, 4 PL

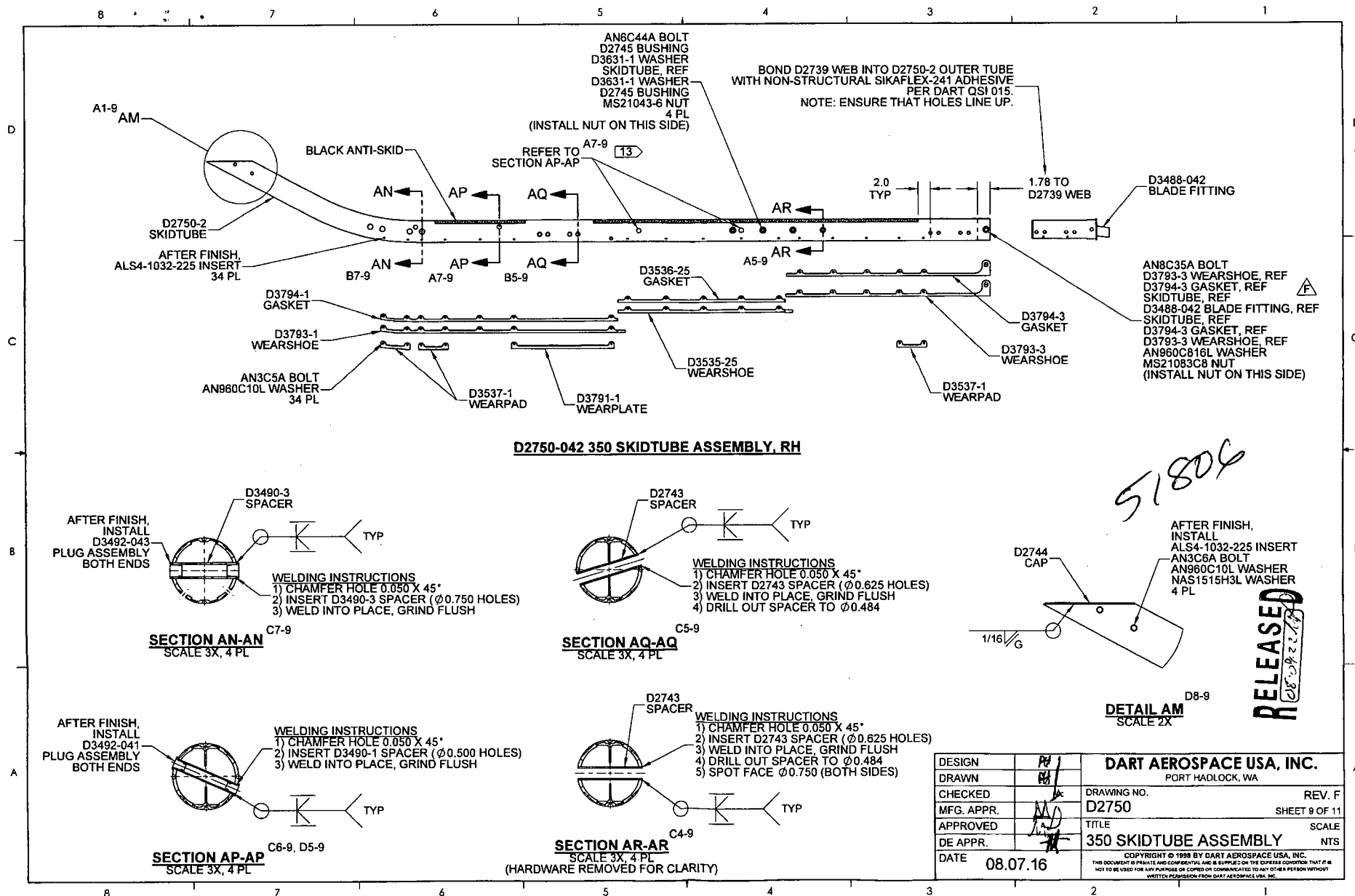


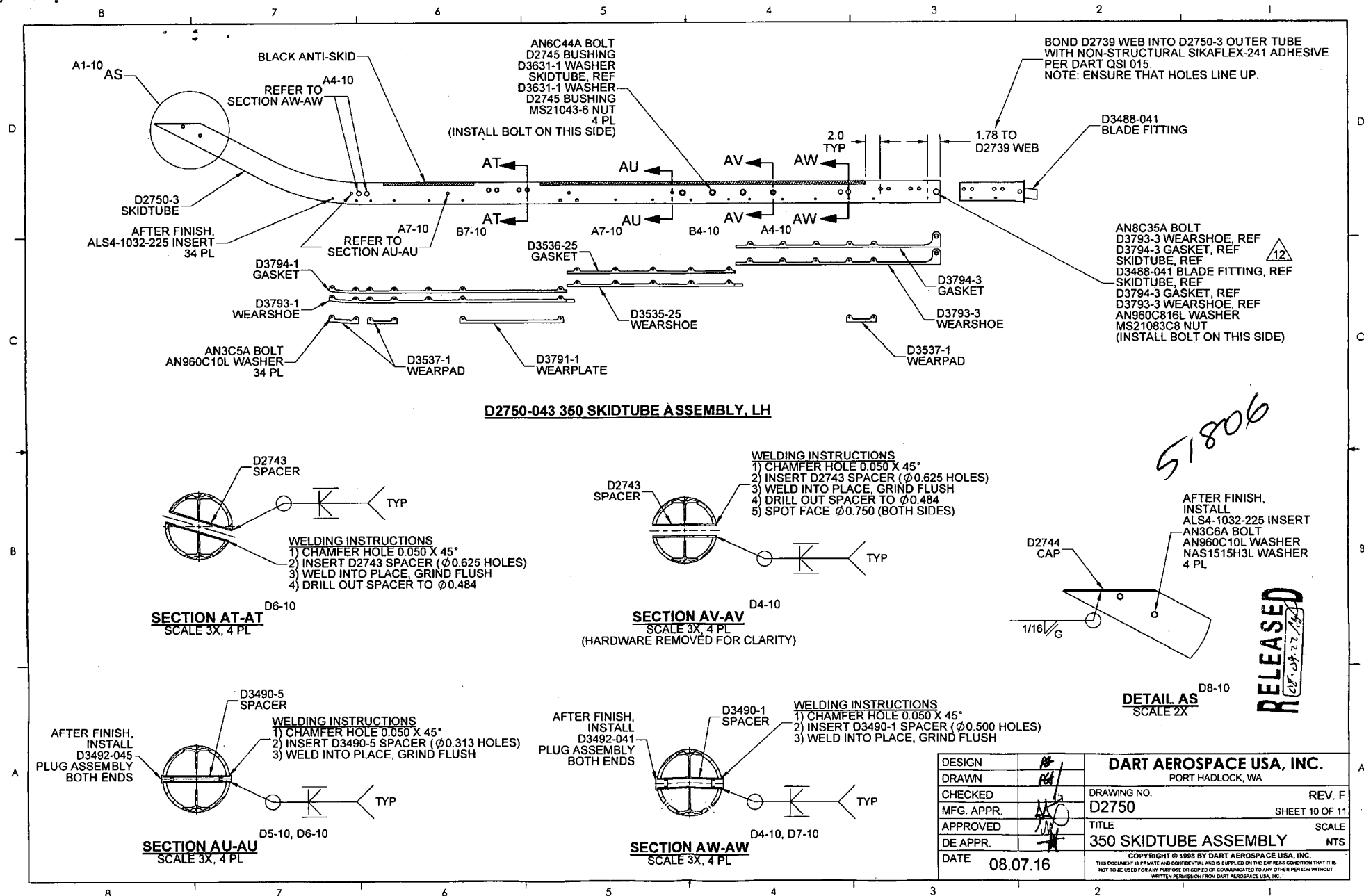
SECTION AF-AF
SCALE 3X, 4 PL

DESIGN	PA	DART AEROSPACE USA, INC.	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. F
MFG. APPR.	PA	D2750	SHEET 7 OF 11
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	350 SKIDTUBE ASSEMBLY	NTS
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6.0 PARTS LIST (D350-636-011/-012/-013/-014 SKIDTUBES AT CHANGE 004 OR LATER)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
	X					D350-636-011	SKIDTUBE INSTALLATION, LH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
		X				D350-636-012	SKIDTUBE INSTALLATION, RH, STD AERAZUR/APICAL CYLINDRICAL FLOAT COMPATIBLE
			X			D350-636-013	SKIDTUBE INSTALLATION, LH AIRCUISEUR/ APICAL TRI-BAG FLOAT COMPATIBLE
				X		D350-636-014	SKIDTUBE INSTALLATION, RH AIRCUISEUR/ APICAL TRI-BAG FLOAT COMPATIBLE
					X	D350-636-045	WEARSHOE KIT
1	1					D2750-041	SKIDTUBE ASSEMBLY, LH
1		1				D2750-042	SKIDTUBE ASSEMBLY, RH
1			1			D2750-043	SKIDTUBE ASSEMBLY, LH
1				1		D2750-044	SKIDTUBE ASSEMBLY, RH
*1	1					D2750-1	SKIDTUBE WELDMENT, LH
*1		1				D2750-2	SKIDTUBE WELDMENT, RH
*1			1			D2750-3	SKIDTUBE WELDMENT, LH
*1				1		D2750-4	SKIDTUBE WELDMENT, RH
**2	8	8	8	8		350A41-1027-20	SCREW
**3	8	8	8	8		23119AG120LE	WASHER
**4	8	8	8	8		22541N120	NUT
*5	1	1	1	1		AN8C35A	BOLT
*6A	1	1	1	1		AN960C816L	WASHER
*7	1	1	1	1		MS21083C8	NUT
*8	1		1			D3488-041	BLADE FITTING, LH
*8		1		1		D3488-042	BLADE FITTING, RH
9	1	1	1	1		D2741	BLADE
10	2	2	2	2		AN8C21A	BOLT
11A	2	2	2	2		AN960C816L	WASHER
11B	2	2	2	2		NAS1515H8L	WASHER
12	2	2	2	2		MS21083C8	NUT
*14	4	4	4	4		AN6C44A	BOLT
*15	8	8	8	8		D2745	BUSHING
*16	4	4	4	4		MS21043-6	NUT
*17	8	8	8	8		D3631-1	WASHER
*18	4	4	4	4		ALS4-1032-225	INSERT
*19	4	4	4	4		AN3C6A	BOLT
*20A	4	4	4	4		AN960C10L	WASHER
*20B	4	4	4	4		NAS1515H3L	WASHER

(CONTINUED ON NEXT PAGE)

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Revision: F

Date: 08.08.14

(CONTINUED FROM PREVIOUS PAGE)

Item	Qty -011	Qty -012	Qty -013	Qty -014	Qty -045	Part Number	Description
*22	3	3	3	3	3	D3537-1	WEARPAD
*22A	1	1	1	1	1	D3791-1	WEARPLATE (REPLACES D3537-1)
*23A	1	1	1	1	1	D3793-1	WEARSHOE (REPLACES D3535-13)
*23B	1	1	1	1	1	D3794-1	GASKET (REPLACES D3536-13)
*24A	1	1	1	1	1	D3535-25	WEARSHOE
*24B	1	1	1	1	1	D3536-25	GASKET
*25A	1	1	1	1	1	D3793-3	WEARSHOE (REPLACES D3535-35)
*25B	1	1	1	1	1	D3794-3	GASKET (REPLACES D3536-35)
*26A	34	34	34	34	34	AN3C5A	BOLT
*27	34	34	34	34	34	AN960C10L	WASHER
*28	34	34	34	34		ALS4-1032-225	INSERT
*30	8	8	8	8		D3492-041	PLUG ASSEMBLY
*31	8	8				D3492-043	PLUG ASSEMBLY
*32			8	8		D3492-045	PLUG ASSEMBLY
****43	2	2	2	2		D3493-1	WASHER
50	2	2				D3532-1	SPACER

* PART OF D2750-041/-042 OR D2750-043/-044 ASSEMBLY

** TO BE SUPPLIED BY CUSTOMER

*** ONLY INSTALLED IF INSTALLING AN APICAL FLOAT SYSTEM

51806

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Revision: F
Date: 08.08.14

NO. 203

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 5011
Part number: D350 636 014
Description: 350 skid tube
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier P. D. D. Date of Test Coupon 09.07.14

Welder Barclay Elliott Date of Test Coupon 09.07.14

The above named individual is qualified in accordance with AWS D17.1.2001 to weld